

Work Order ID 52883

October 16, 2009 10:11:12 AM



Page 1

Item ID: D3296-041
Revision ID: A
Item Name: Door Assembly

Accept



Setup Start



Stop



Start Date: 16/10/2009 Start Qty: 8.00
Required Date: 02/11/2009 Req'd Qty: 8.00



Cust Item ID:
Customer:

Reference:

Run Start



Approvals: Process Plan: BL Date: 09-16-16 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3296	Rev A								
100	Small Fab	0.00							
	Small Fab								
	Memo	0.00							
	Fabricate & assemble as per Dwg D3296.								
	Transfer drill using DT8470 & DT9521								
110	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
	Memo	0.00							
	Quality Control								
120	Black Sandtex(Ref:4.3.5.7) per QS1005 4.3	0.00							
	Powdercoat								
	Powder Coating								

9/509/10/21 (8)

8/20/10/21

(8)

7/20/10/21

(X8) 6

Memo
START TIME: 3:15pm
FINISH TIME: 3:45pm
COVEN TEMPERATURE: 320°F

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Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	OK 09-10-21			(8)			
140 Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D3296	0.00 0.00				Epo 09/10/22 (8)			
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	SOL 10/22			(8)	f		

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Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>218</u>	0.00							
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/10/23

09.10.27

MF 09-10-24

Picklist Print

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Work Order ID: 52883

Parent Item: D3296-041RevA

Parent Item Name: Door Assembly

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
--------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3161-7RevA2
Hinge 14.0"

Manufactured No

100

Each

16.0000

8.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

51601

1

Main Warehouse

ST069

15

52029

15

100

Each

5.0000

8.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

51632

1

Main Warehouse

ST73

4

51174

4

B 53000

(3X)

09/10/20

(1X)

(7X)

09/10/20

(5X)

Picklist Print

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Parent Item Name: Door Assembly

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 8.00

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Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3296-1RevA

Manufactured

No

100

Each

8.0000

8.0000



Door Panel

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8

50765

8

D3296-3RevA

Manufactured

No

100

Each

0.0000

8.0000



Door Panel

B 52271 (8K)

MS20470AD4-6

Purchased

No

100

Each

2,325.000

8.0000



Rivet, Universal Head

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2325

109371

64

110915

746

112492

1515

Picklist Print

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Parent Item: D3296-041RevA

Parent Item Name: Door Assembly

Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD6

Purchased

No

140

Each

1,475.000 8.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1475

104537

1114

6085

361

D2137

Manufactured

No

140

Each

28.0000 8.0000



Decal - No Step

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

28

108012

1

45851

1

52033

26

D2419RevA

Manufactured

No

140

Each

19.0000 8.0000



Handle

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST031

19

52028

19

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Shop Packet Print

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Picklist Print

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Work Order ID: 52883

Parent Item: D3296-041RevA

Parent Item Name: Door Assembly




Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2462RevA1  Seal		Manufactured	No			140	f	773.8344	2.6664			
				<u>Warehouse</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				<u>Location</u>								
				Main Warehouse								
				ST404				773.8344				
				48530				773.8344				
D2728-1RevB  Dart Logo label		Manufactured	No			140	Each	0.0000	0.0000			
MS20470AD4-4  Rivet, Universal Head		Purchased	No			140	Each	3,307.000	200.0000			
				<u>Warehouse</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				<u>Location</u>								
				Main Warehouse								
				ST				3307				
				111359				88				
				112314				3219				

October 16, 2009 10:10:21 AM

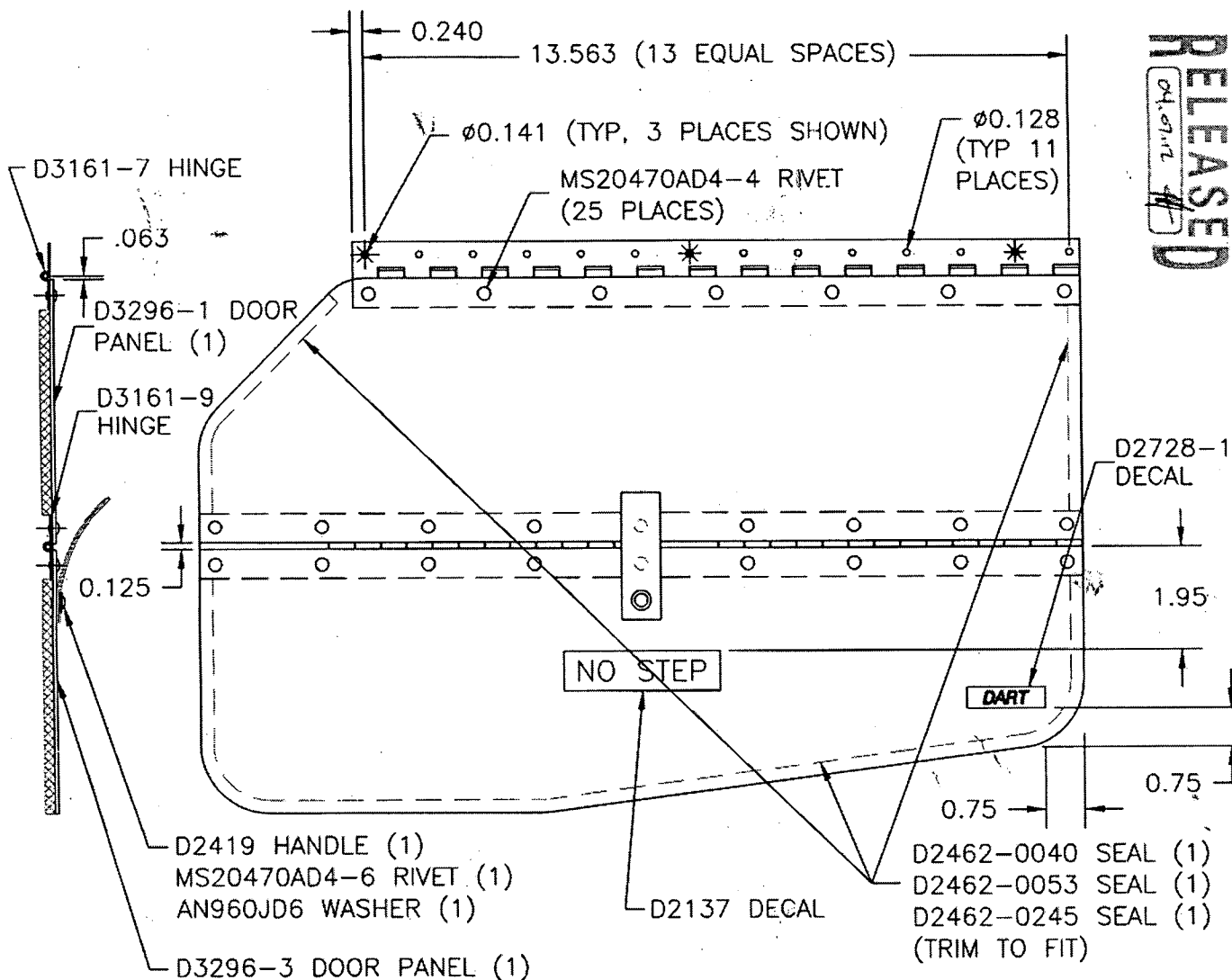
Shop Packet Print

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09-10-16

RELEASED
04.07.12



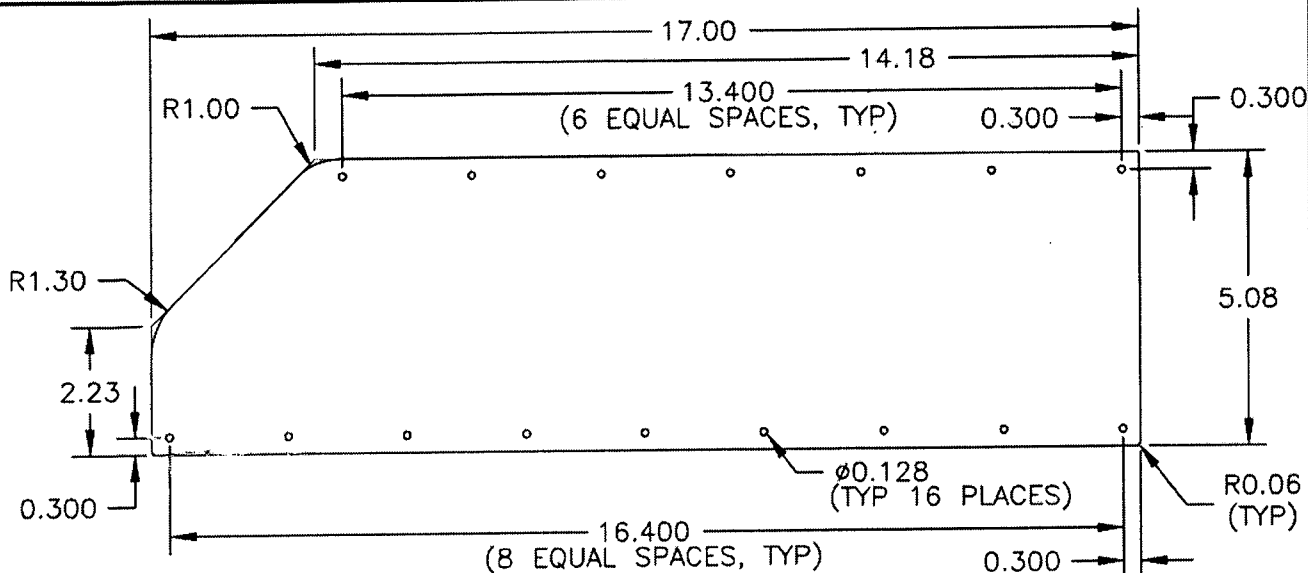
D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

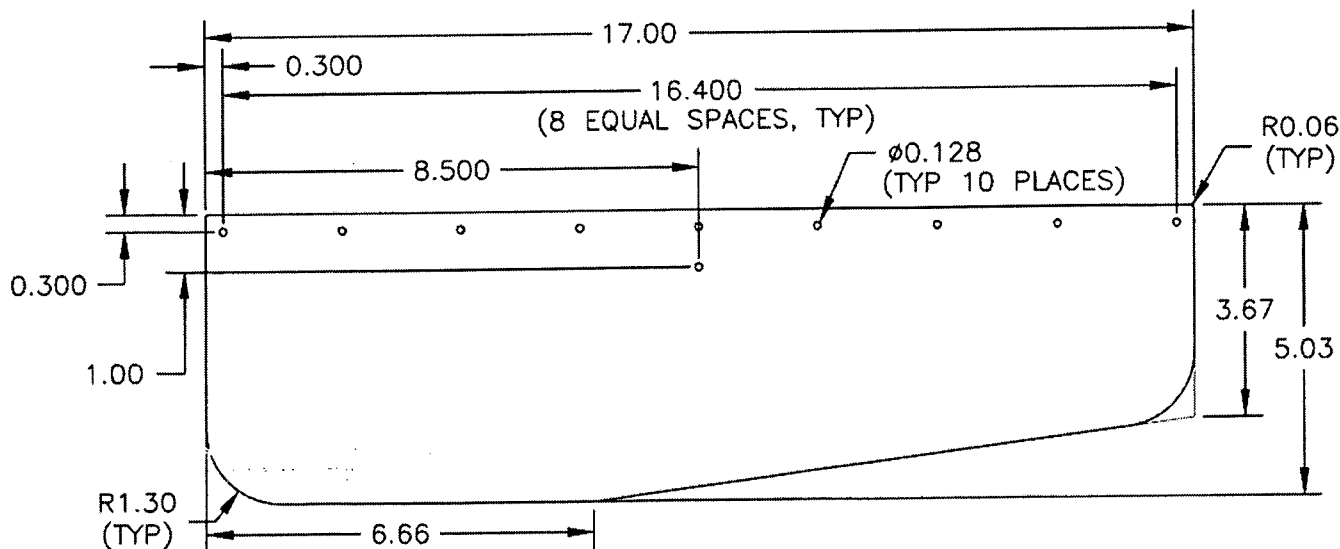
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO.
DATE	DATE	TITLE
04.06.28	04.06.28	DOOR ASSEMBLY
A	NEW ISSUE	SCALE
		1:3



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28	TITLE DOOR ASSEMBLY		SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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